

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
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Work Order ID 103508

103508

Page 2

June-24-13 1:57:15 PM

Item ID: D2582

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hi-Skid Step Leg Ass'y

Start Date: 6/24/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/05/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

[Handwritten signature]
13-11-05
13-17-01

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June-24-13 1:57:14 PM

Required Qty: 10.00

Comments:	IPP Rev:F	Removed Manufacturing	05-11-07	JLM	
	IPP Rev:G	Added part # to Sub	06-08-10	JLM	
	IPP Rev H	New pick list	08.01.11	EC	verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2278		Manufactured	No			100	Each	20.0000	2	20	13/10/18		DAS 36 9-89
Step Leg													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				B104338 (6x)	
				GA		20							
				97981		12						B103622 (18x)	
				98440		8							
D2279		Manufactured	No			100	Each	33.0000	1	10	13/10/18		DAS 36 9-89
Step Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		33							
				73048		2							
				86718		4							
				90014		27							
D2322		Manufactured	No			100	Each	16.0000	1	10	13/10/18		DAS 36 9-89
Step Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		16							
				67611		4							
				97944		12							
D3720-1		Manufactured	No			100	Each	21.0000	1	10			DAS 36 9-89
Step Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		21							
				87656		1							
				90176		20							

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Picklist Print

June-24-13 1:57:14 PM

Page 2

Work Order ID: 103508

Parent Item: D2582

Parent Item Name: Hi-Skid Step Leg Ass'y

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 10.00

Required Qty: 10.00

D3720-2 Manufactured No

100 Each 7.0000

1 10

13/10/18 DAS 36 9-89

Location

Loc Qty

Loc Code

GA 89810

7 7

B103600 (12x) DAS 36 9-89

MS20470AD4-4 Purchased No

100 Each 5,920.0000

22 220

13/10/18 DAS 36 9-89

Location

Loc Qty

Loc Code

GA 121652

1 1

ST336

2891

116188

68

118614

135

122027

188

m125807

2500

ST506

3028

125268

3028

220 264x

MS20470AD4-5 Purchased No

100 Each 2,157.0000

4 40

13/10/18 DAS 36 9-89

Location

Loc Qty

Loc Code

GA 122452

218 218

ST336

1939

122452

584

125654

1355

M126926 (40x)

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Shop Packet Print

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D2278 STEP LEG
(2 PLACES)

MS20470AD4-4 RIVET
(5 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2279 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET
(6 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET
(2 PLACES)

MS20470AD4-5 RIVET
(2 PLACES)

B
D3720-2 STEP SPACER

B
D3720-1 STEP SPACER

C'SINK ON INSIDE
GRIND RIVET FLUSH TO
SURFACE AS REQUIRED
(BOTH SIDES)

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

103508 M.C.
13-06-26

RELEASED
06-01-10

B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	LE	D2582	SHEET 1 OF 1
MFG. APPR.	LE	TITLE	SCALE
APPROVED	LE	STEP LEG ASSEMBLY	NTS
DATE	07.12.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. USE IS LIMITED TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	